

Work Order ID 131504

Monday, April 13, 2015 10:04:00 AM

131504

0205-54-000

Page 1

Item ID: D3053-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 212 Basket Base Assembly
 Start Date: 4/13/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/1/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 5-4-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3053	C								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.04							
Large Fab	1-Cut 5 D2235-3 FROM D3166-1 using DT8365								
	2-Cut Ribs from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing as per dwg.								
	3-Remove all markings from material								
	4-Drill holes in D3053-3 as per dwg D3053								
	5-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995								
	6- Cut mesh as per dwg								
110	Weld per dwg A/R S.S. rod Batch: <u>4130267</u>	0.00							
110	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1 -Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required								

1x **DAS 43** **APR 27 2015**

1x **DAS 43** **APR 27 2015**

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Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 4/13/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 5/1/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

OC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop ***NR2***

[illegible]

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00	M131545			1	0	15-4-30	2348
150	Memo	0.01	2ND COAT.						
Powdercoat	START TIME: 1:15		START: 2:20						
Powder Coating	OVEN TEMPERATURE: 400°		OVEN T: 400°						
	FINISH TIME: 1:45		FINISH: 2:50						
160	QC3- Inspect Part Finish	0.00							
160	Memo	0.00							
QC									
Quality Control									
170	Identify as per dwg & Stock Location: W16	0.00							
170	Memo	0.00							
Packaging									
Packaging									

DAS
15
9-89

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Item ID: D3053-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MCS MAY 06 2015

MCS MAY 06 2015

Picklist Print

Monday, April 13, 2015 10:03:59 AM

Page 1

Work Order ID: 131504

131504

Parent Item: D3053-042

D3053-042

Parent Item Name: 212 Basket Base Assembly

Start Date: 4/13/2015

Required Date: 5/1/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C02.09.04M304EX0.75-16F was M750-16FXS-S/SKJ/RF
IPP Rev:D 08-08-29 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3166-1		Manufactured	No			100	Each	19.0000	5	5			
D3166-1									**		DAS 43	DAS 43	APR 15 2015
Basket Hoop											9-89	9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				19					
				125268				1					
				125270				6			2x		
				127860				12			3x		
M304EX0.75-16F		Purchased	No			100	sf	1,014.861	48	51			
M304EX0 75-16F									**		DAS 43	DAS 43	APR 15 2015
Expanded Metal Flat SS											9-89	9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				446					
				M131848				446					
				WA006				568.8612					
				M131107				129.8612					
				M131629				439					
M304TS0.750W.065		Purchased	No			100	f	997.3500	43.3333	46			
M304TS0 750W 065									**		DAS 43	DAS 43	APR 15 2015
304 SQ Tube .75x.75x.065W											9-89	9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				997.35					
				125513				14					
				m128495				389.35					
				m131206				594					

B 131206 → 46 feet

Picklist Print

Page 2

Monday, April 13, 2015 10:04:00 AM

Work Order ID: 131504

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Parent Item: D3053-042

D3053-042

Parent Item Name: 212 Basket Base Assembly

Start Date: 4/13/2015

Required Date: 5/1/2015

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No

110 Each

36.0000 2 2

DAS

D2232-3

Basket Hinge

**

B103653 → 2x 43 9-89

APR 27 2015

Location

Loc Qty

Loc Code

WA004

36

101778

16

115847

20

D2327-3 Manufactured No

110 Each

46.0000 2 2

DAS

D2327-3

Spacer Bushing

**

B103679 → 2x 43 9-89

APR 27 2015

Location

Loc Qty

Loc Code

WA004

46

100523

25

103679

21

D2581 Manufactured No

110 Each

91.0000 2 2

DAS

D2581

Mounting Bracket

**

B102265 → 2x 43 9-89

APR 27 2015

Location

Loc Qty

Loc Code

WA004

91

102265

36

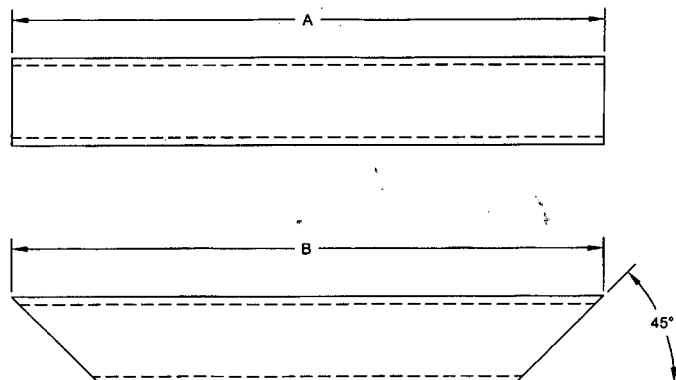
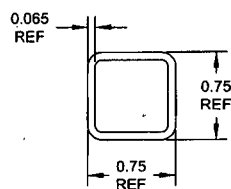
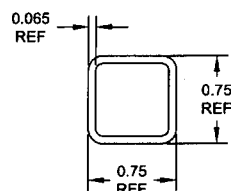
127716

39

131144

16

QTY -041	QTY -042	PART NO	LENGTH A	LENGTH B	DESCRIPTION
X		D3053-041	N/A	N/A	BASKET BASE ASSY
	X	D3053-042	N/A	N/A	BASKET BASE ASSY
2	2	D3053-1		96.00	RIB
2	2	D3053-3		25.50	RIB
6	6	D3053-5	23.73		RIB
3	3	D3053-7	25.31		RIB
3	3	D3053-9	19.48	N/A	RIB
2	2	D2327-3	N/A	N/A	BUSHING
2	2	D2581	N/A	N/A	MOUNTING BRACKET
2	2	D2232-3	N/A	N/A	HINGE PLATE
5	5	D2235-3	N/A	N/A	RIB



D3053-X RIB

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 10) WELD PER DART QSI 004

C	ADD -041 VIEWS, ZN B4-2, D4-2, B7-2. RE-ORGANIZE DWG. REF NCR13-2766.	DC	13.12.12
B	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.02
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	13.12.12	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

131504

DQA: _____ Date: _____

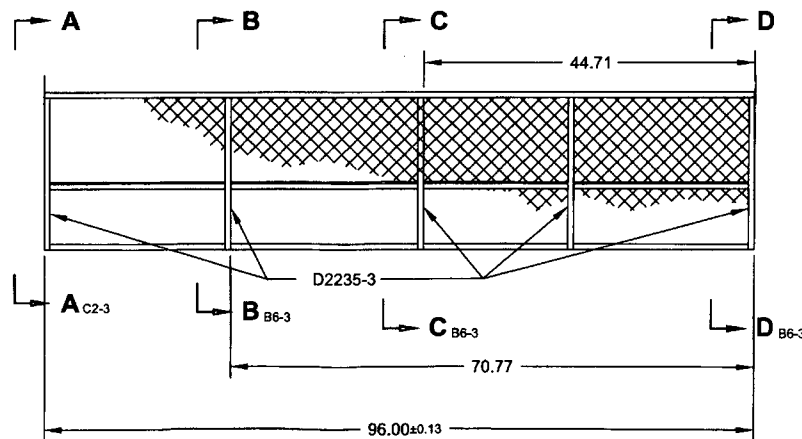
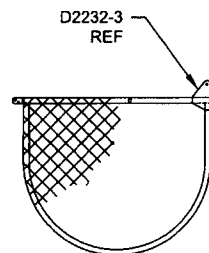
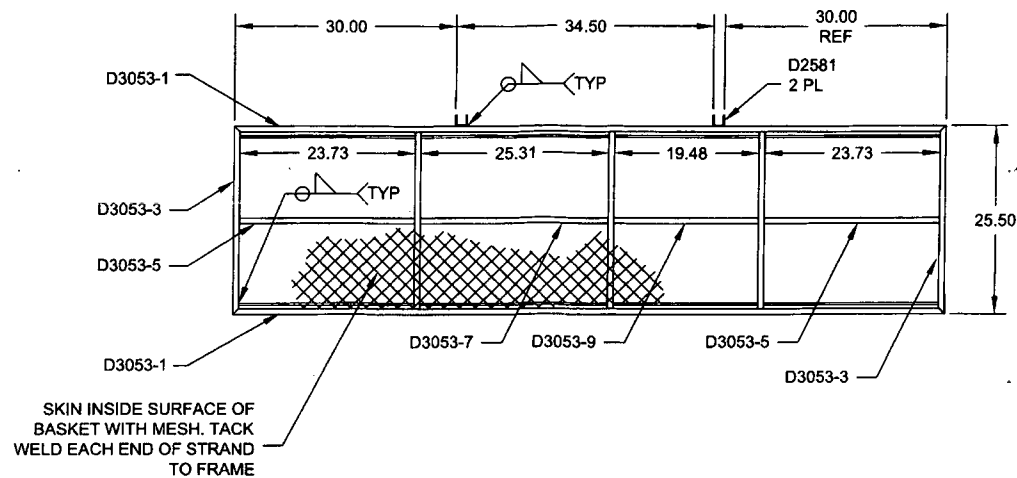


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					



D3053-041 BASKET BASE ASSEMBLY

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
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DQA: _____ Date: _____

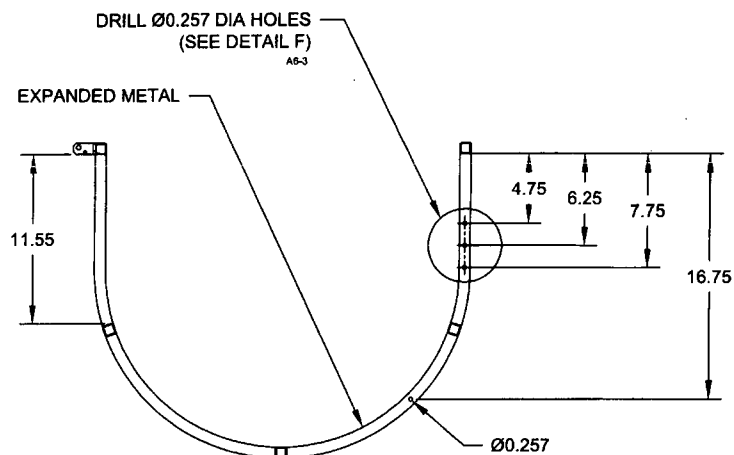


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

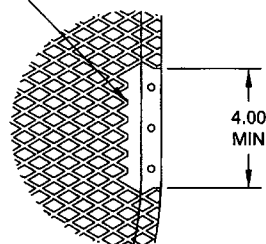
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

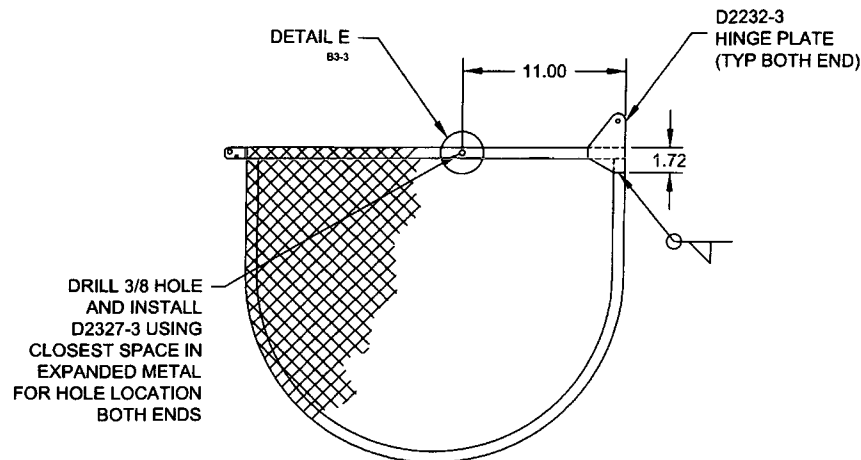


SECTION B-B
SECTION C-C
AND SECTION D-D
RIB DETAIL

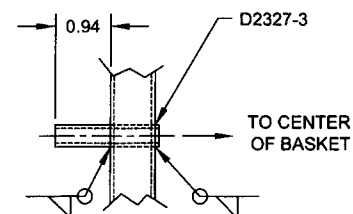
CUT AWAY EXPANDED
METAL TO NEAREST
INTERSECTIONS AS SHOWN
SECTION D-D ONLY



DETAIL F
SCALE NONE



SECTION A-A
SPACER DETAIL



DETAIL E
SCALE 4X

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 3 OF 5
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DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
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DQA: _____ Date: _____



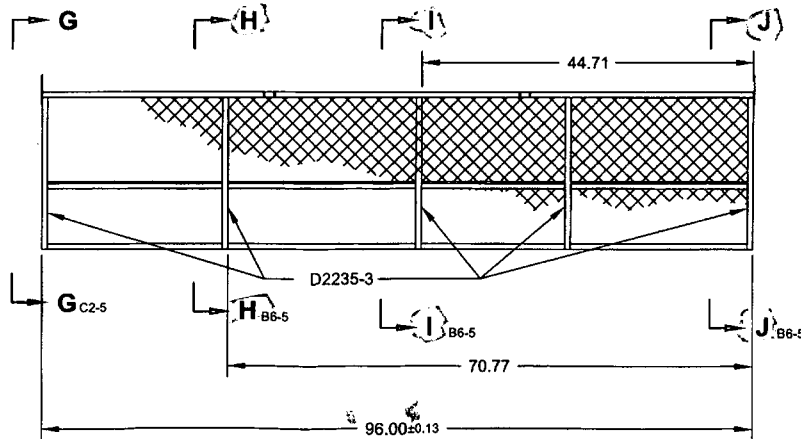
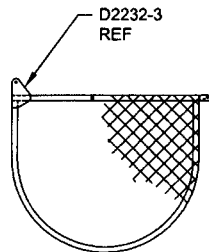
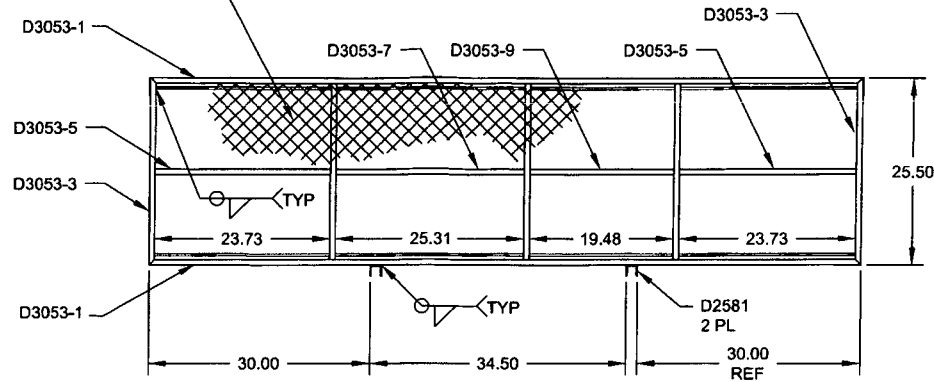
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SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME



D3053-042 BASKET BASE ASSEMBLY SHOWN

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	13.12.12	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

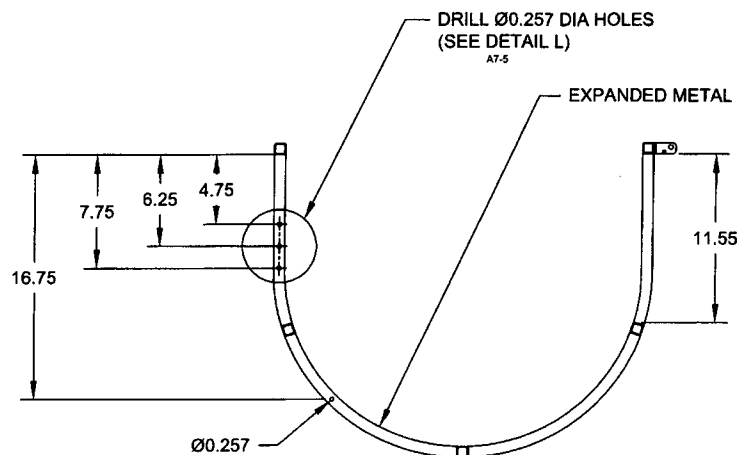


WORK ORDER NON-CONFORMANCE / UPDATE

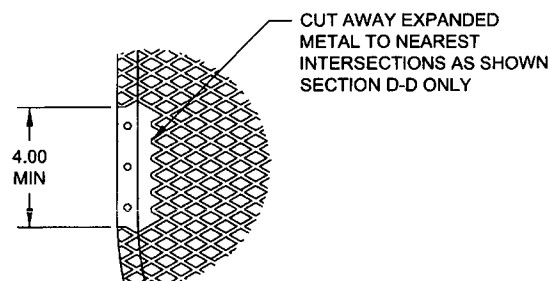
QA Closed: _____ Date: _____

Work Order update only ☐

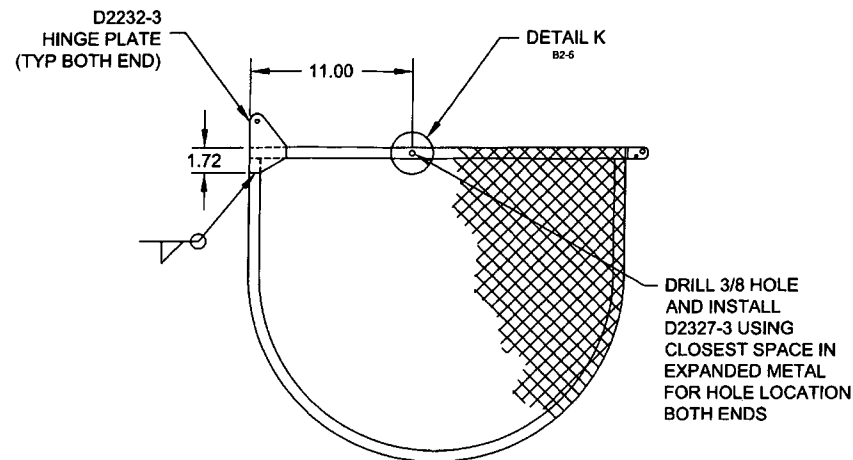
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Root Cause				FAULT CATEGORY																					
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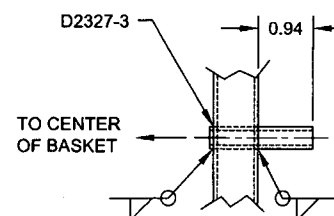
SECTION H-H
B5-4
SECTION I-I
B4-4
AND SECTION J-J
B3-4
RIB DETAIL



DETAIL L
SCALE NONE
C7-5



SECTION G-G
B6-4
SPACER DETAIL



DETAIL K
SCALE 4X
D3-5

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	DD	D3053	SHEET 5 OF 5
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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